

# Work Order ID 63842

Tuesday, November 16, 2010 1:16:12 PM



Page 1

Item ID: D3319-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 11/17/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 11/24/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-11-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	Rev B								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1010 - 1050

1-Cut as per Dwg D3319 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

B 10-11-17

(9)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 10-11-17

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

10/16/17

(XS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

N/A

Small Fab

Deburr if necessary

140



Brake NC

NC BRAKE

0.00

Memo

0.00

SB 10/11/22

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: B

9

150



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

SB 10/11/22

Quality Control

9

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Item Name: Wearplate

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Start Date: 11/17/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 11/24/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: □ Qty Part Number Description Batch □ A/R N/A 7560 Hardcoat Rod M 116678								
170 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11-1-24 11-1-24 (X9)

Subs

Subs

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






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**NOTE:** Date & initial all entries




# Work Order ID 63842

Tuesday, November 16, 2010 1:16:12 PM

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Item ID:	D3319-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearplate					
Start Date:	11/17/2010	Start Qty:	8.00		Cust Item ID:	
Required Date:	11/24/2010	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>M112588</i> Memo START TIME: <i>11:30</i> <i>320°</i> FINISH TIME: <i>12:00</i> <input type="checkbox"/> OVEN TEMPERATURE:	0.00 0.00				<i>9</i>	<i>BL</i>	<i>11-01-26</i>	
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	<i>HL</i>	<i>11/01/26</i>		<i>9</i>	<i>φ</i>		
210  Packaging Packaging	Packaging  Memo Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3319-3, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA05-18 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <i>497</i>	0.00 0.00						<i>11/01/26</i>	<i>(9)</i>

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**Work Order ID 63842**

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Item ID: D3319-3

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Revision ID:

Item Name: Wearplate

Start Date: 11/17/2010 Start Qty: 8.00

Required Date: 11/24/2010 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/27 J

N. L. 11/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 1:16:11 PM

Page 1

Work Order ID: 63842



Parent Item: D3319-3



Parent Item Name: Wearplate


Start Date: 11/17/2010

Required Date: 11/24/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A 05.05.12 New issue KJ/JLM  
IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA  1010/1025 SHEET .048		Purchased	No			100	sf	34.0000	3.2524	27.38863			



B10-11-17

Location

Loc Qty

Loc Code

MAT

34

116031

34

116031

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	63842
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3319-3
<b>Inspection Dwg:</b> D3319	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	*		T B01	
74.420	+/-0.010	74.420	2		T	
62.770	+/-0.010	62.770	2		T	
52.890	+/-0.010	52.890	0		T	
30.790	+/-0.010	30.790	2		T	
8.690	+/-0.010	8.690	2		T	
0.60	+/-0.030	0.600	*		J B02	
2.690	+/-0.010	2.698	*		✓	
2.940	+/-0.010	2.949	*		✓	
3.527	+/-0.010	3.524	*		✓	
4.518	+/-0.010	4.518	*		✓	
Ø0.190	+0.005/-0.001	0.194	*		✓	
2.940	+/-0.010	2.940	*		✓	
2.940	+/-0.010	2.949	*		✓	
2.690	+/-0.010	2.700	*		✓	
5.063	+/-0.010	5.059	*		✓	
6.163	+/-0.010	6.164	*		✓	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	0.317 x 0.609	*		✓	
0.048	+/-0.010	0.048	*		✓	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-11-17	<b>Date:</b> 10/11/17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

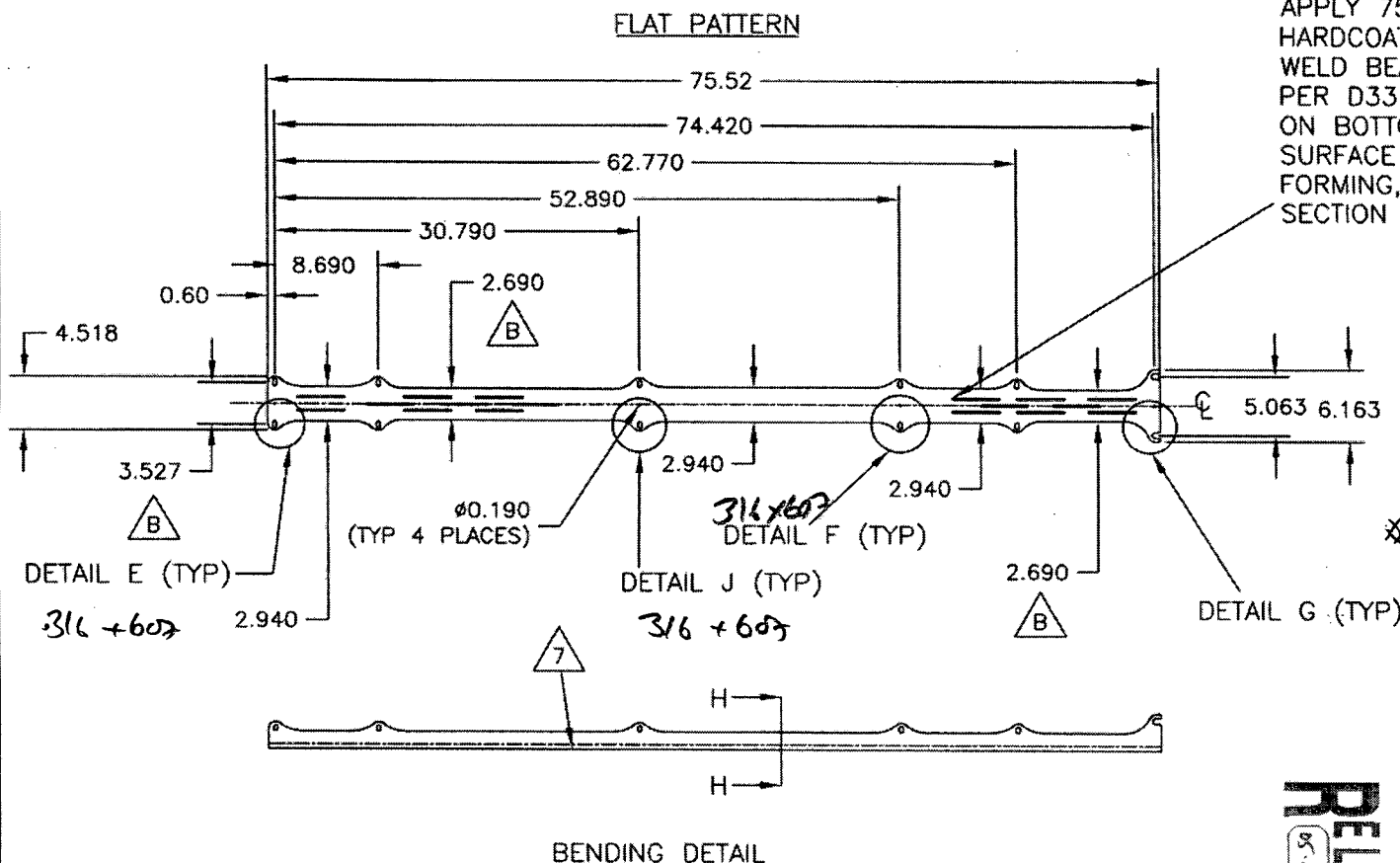
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED	04	APPROVED	04	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
			WEARPLATE	SHEET 2 OF 5
				SCALE 1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



# **D3319-3 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**RELEASED**  
05.07.30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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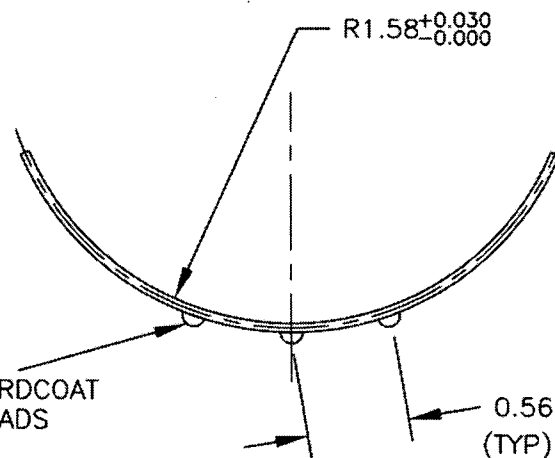
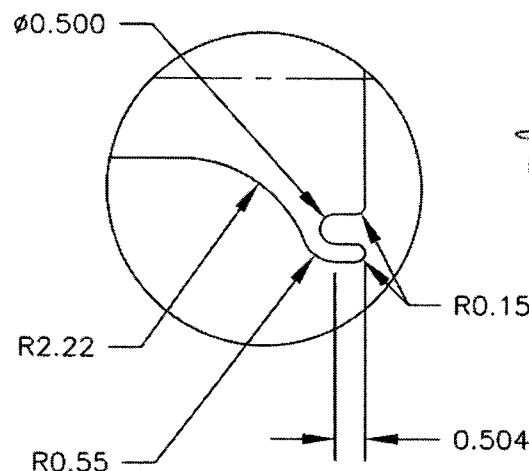
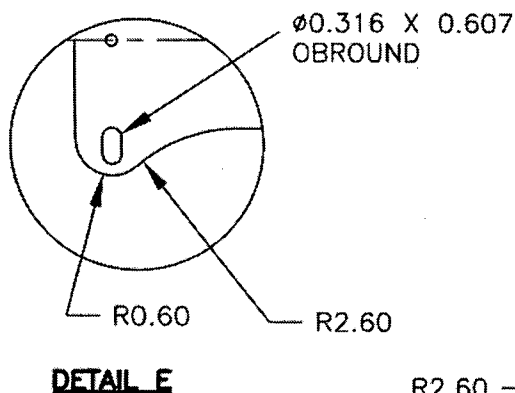
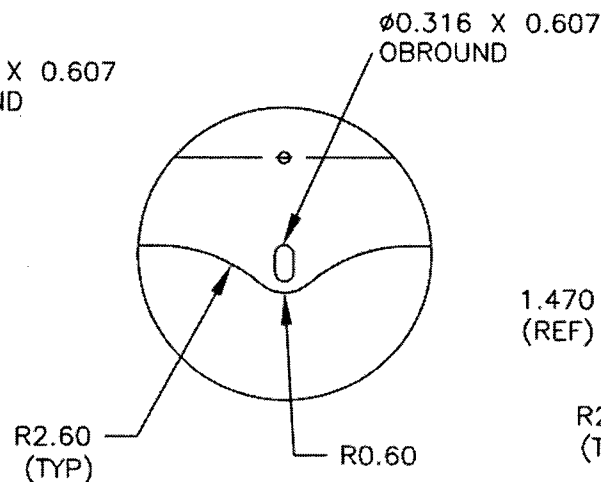
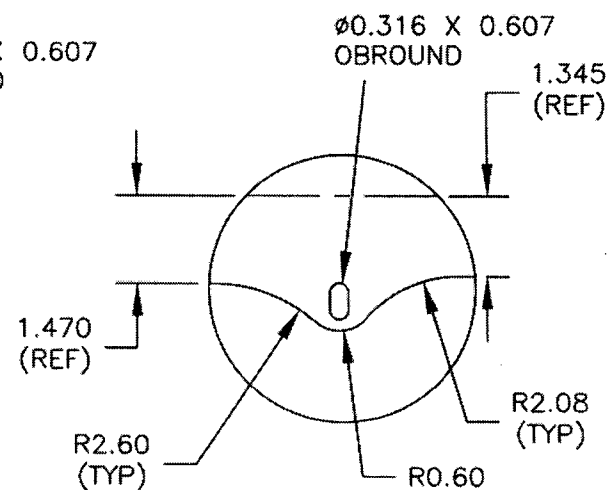


**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHKD	APPROVED	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D5319	SHEET 5 OF 5
05.06.06		TITLE	SCALE
		WEARPLATE	1:3

RELEASED  
05.09.30

#63842



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